

Date: Monday, 05/05/2008 8:25:00 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET
 Job Number : 39026
 Estimate Number : 13300
 P.O. Number :
 This Issue : 05/05/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D2127251061
 First Issue : 11 Type : SMALL /MED FAB Drawing Number : D212-725-1 P.25REVB
 Previous Run : Project Number : N/A
 Material :
 Due Date : 12/05/2008 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-05-01 new issue DD verified by:EC

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description :

1.0 M2024T3S040 2024-T3 .040 sheet

Comment: Qty.: 0.2730 sf(s)/Unit Total: 1.3650 sf(s)
 2024-T3 0.040 Sheet

Batch: 1015001 IB 8-5-6

2.0 WATER JET FLOW WATER JET

Comment: FLOW WATER JET
 1-Cut as per Dwg D212-725-1
 Dwg Rev: B
 Prog Rev: B

2- Deburr if necessary IB 8-5-6

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK

Comment: SECOND CHECK

5.0 BRAKE NC NC BRAKE

Comment: NC BRAKE
 Bend as per Dwg D212-725-1 p.25

WIO: 39026-2		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
03.05.06	2	QTY (4) ϕ 0.03 notes changed to ϕ 0.030 PER RF, SEE ATTACHED	PA	08.05.06	ALL	PA per QSS 04h 03.05.06	5 06.05.06

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 39026

Part Number: D2127251061

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

8.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

10.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 1003-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PART AEROSPACE LTD		Work Order: 39026
Description: BRACKET		Part Number: D212-725-1
Inspection Dwg: D212-725-1	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

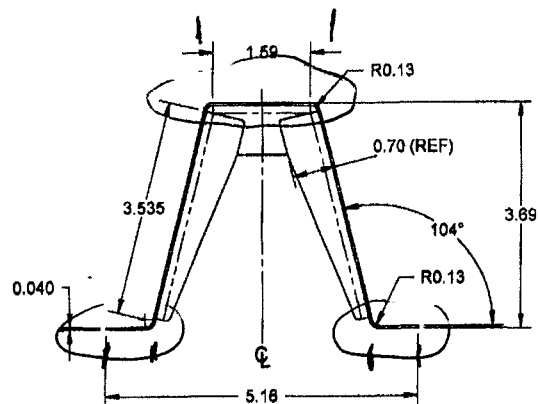
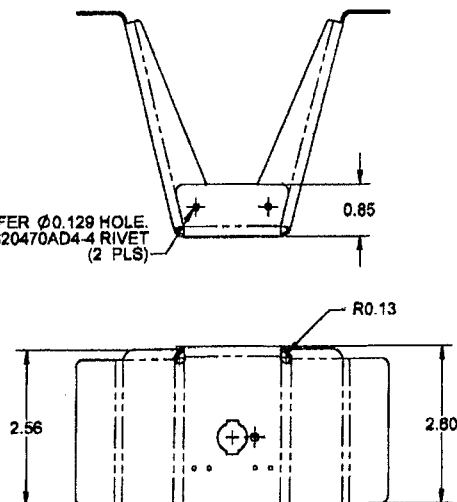
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.083	+ .004 - .001	.083	*			
Ø .098	+ .004 - .001	.102	*			
Ø .129	+ .005 - .001	.131	*			
3.348	+/- .010	3.349	*			
10.727	+/- .010	10.727	*			
2.394	+/- .010	2.393	*			
3.157	+/- .010	3.160	*			
.903	+/- .010	.905	*			
8.921	+/- .010	8.921	*			
1.100	+/- .010	1.101	*			
.600	+/- .010	.604	*			
.250	+/- .010	.250	*			
.550	+/- .010	.556	*			
1.250	+/- .010	1.248	*			
1.250	+/- .010	1.250	*			
.368	+/- .010	.369	*			
.396	+/- .010	.396	*			
1.183	+/- .010	1.183	*			
1.975	+/- .010	1.978	*			
4.376	+/- .010	4.377	*			

Measured by: HB	Audited by: [Signature]	Prototype Approval: [Signature]
Date: 8-5-7	Date: 08/05/07	Date: [Signature]

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

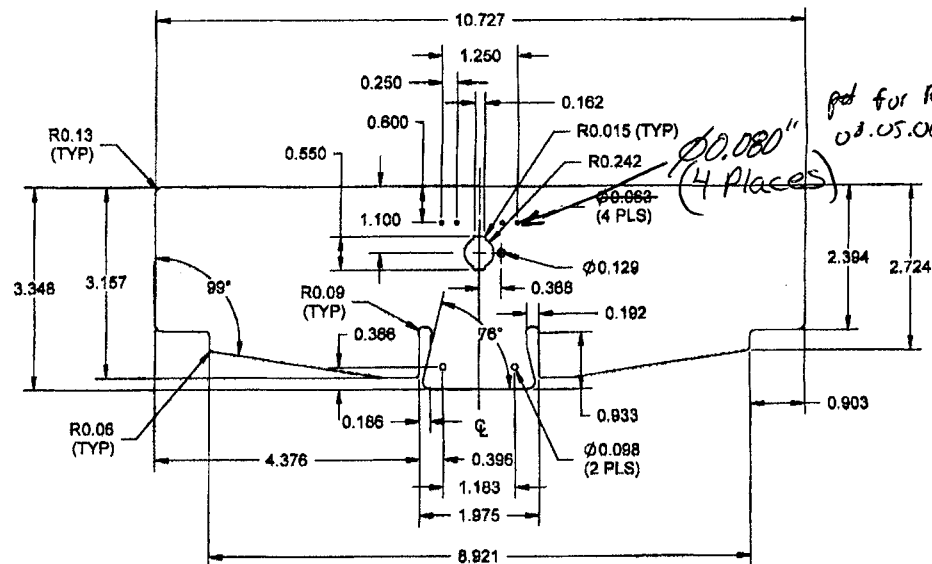
TRANSFER $\phi 0.129$ HOLE.
INSTALL MS20470AD4-4 RIVET
(2 PLS)



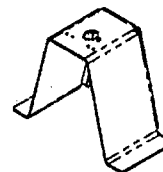
D212-725-1-061 BRACKET
(MAKE FROM D212-725-1-061F FLAT PATTERN)

NOTES:

- 1) MATERIAL: 2024-T3 SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER



D212-725-1-061F FLAT PATTERN



B	07.05.11	NO CHANGE
A	06.12.08	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1
DATE 07.05.11	TITLE 212S DETAIL PARTS	REV. B SHEET 25 OF 44 SCALE 1:2

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Peter Hum

From: Roberto Fuentes [rfuentes@dartaero.com]
Sent: May 6, 2008 2:54 PM
To: 'David Duval'
Cc: David Shepherd; Chris Provencal; Peter Hum (Peter Hum); Mike Petsche
Subject: RE: DXF

It is acceptable to make those 4 holes 0.080"; we are going to the change for that in the next revision of D212-725 drawings. For now let Chris or Peter sign a deviation for you WO.

Roberto

From: David Duval [mailto:dduval@dartaero.com]
Sent: Tuesday, May 06, 2008 11:45 AM
To: 'Roberto Fuentes'
Cc: Linda Lacelle
Subject: RE: DXF

On the dwg it calls for 4 holes at 0.063". We can't water jet these holes because they are to small. Can we put them at 0.080" that is the smalls we can go?

Thanks,

David Duval
Production Engineering Coordinator
DART aerospace Ltd.
T(613)632-5200
F(613)632-4443
dduval@dartaero.com

From: Roberto Fuentes [mailto:rfuentes@dartaero.com]
Sent: Friday, May 02, 2008 4:06 PM
To: 'David Duval'
Cc: 'Linda Lacelle'
Subject: RE: DXF

D212-725-1-061 dxf.

Roberto

From: David Duval [mailto:dduval@dartaero.com]
Sent: Friday, May 02, 2008 1:03 PM
To: 'Roberto Fuentes'
Cc: Linda Lacelle
Subject: DXF

Can you send me the DXF for D212-725-1-061

Thanks,

David Duval

06/05/2008